

Work Order ID 71554

Wednesday, July 06, 2011 11:58:03 AM

Page 1

Item ID: D2573

Accept

Revision ID:

Item Name: Saddle, Aft Out 205

Start Date: 7/6/2011 Start Qty: 4.00

Required Date: 7/15/2011 Req'd Qty: 4.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2573

Rev E

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Program Batch No. 71554 Double check by: B.A. 11-Machine Step No
1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step
No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine
Step No 3 per Folio FA051 and insp

aml 11/07/11

4

110

0.00



CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine keyway as per dwg D2573 & D2574

aml 11/07/11

4

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

aml 11/07/11

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 71554

Wednesday, July 06, 2011 11:58:03 AM



Page 2

Item ID: D2573

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, Aft Out 205

Start Date: 7/6/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 7/15/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00							
QC	Memo	0.00				4	0		
Quality Control									
140	Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish	Memo	0.00							
Hand Finishing									
150	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
Powdercoat	Memo	0.00							
Powder Coating									

B.A 11/07/12

H 0 BL 11-7-12

4X 0 M-L 11/07/12

M 117745

3200F

1:45

Memo

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 71554

Wednesday, July 06, 2011 11:58:03 AM

Page 3

Item ID: D2573

Accept

Revision ID:

Item Name: Saddle, Aft Out 205

Start Date: 7/6/2011 Start Qty: 4.00

Required Date: 7/15/2011 Req'd Qty: 4.00

Reference:

Cust Item ID:




Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				4	6	BL 11-7-12	
170  Packaging Packaging	Identify as per dwg & Stock Location: 434 Memo	0.00 0.00							
180  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

11/7/13 (4)

11/7/13

MF
11-07-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, July 06, 2011 11:58:01 AM

Work Order ID: 71554

Parent Item: D2573

Parent Item Name: Saddle, Aft Out 205



Start Date: 7/6/2011

Required Date: 7/15/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: 1 As Per RevE 06-01-27 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D6101-007

Manufactured No

100

Each

55.0000

1

4



Saddle Billet

Location

Loc Qty

Loc Code

MAT042

3

66967

3

MAT045

52

65383

13

65954

1

70678

8

70680

30

4

amk 7/6/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	71554
Description: Saddle, Aft Outboard		Part Number:	D2573
Inspection Dwg: D2573 Rev. E		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		.440	.440	.440	.440		
B	1.745	1.755		1.748	1.748	1.750	1.750		
C	3.495	3.505		3.499	3.499	3.500	3.500		
D	1.745	1.755		1.748	1.748	1.750	1.750		
E	7.990	8.010		8.003	8.002	8.003	8.003		
F	0.490	0.510		.503	.503	.502	.501		
G	0.257	0.262		.259	.259	.259	.259		
H	0.375	0.380		.377	.377	.377	.377		
I	0.490	0.510		.502	.503	.503	.500		
J	1.174	1.184		1.178	1.178	1.179	1.179		
K	0.558	0.578		.569	.570	.570	.568		
L	1.174	1.184		1.178	1.178	1.179	1.179		
M	1.365	1.375		1.369	1.369	1.369	1.369		
N	2.495	2.505		2.499	2.499	2.500	2.500		
O	4.119	4.129		4.122	4.123	4.123	4.123		
P	0.115	0.135		.125	.127	.124	.124		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.257	.249	.257	.249		
S	0.115	0.135		.129	.127	.127	.127		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.230	3.230	3.228	3.230		
V	0.230	0.250		.235	.236	.236	.236		
W	0.115	0.135		.131	.129	.130	.130		
X	0.308	0.313		.309	.310	.310	.310		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.367	.367	.365	.366		
AA	0.470	0.530		.500	.506	.500	.500		
AB	0.615	0.635		.627	.627	.627	.626		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.245	.246	.246	.246		
AE	1.500	1.520		1.515	1.513	1.513	1.511		
AF	0.115	0.135		.130	.130	.130	.130		
AG	0.240	0.280		.275	.275	.275	.275		
AH	0.240	0.260		.242	.246	.246	.248		
AI	2.000	2.020		2.004	2.003	2.005	2.001		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	<i>ork</i>
Date:	11/07/11

Audited by:	B.A
Date:	11/07/12

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

RELEASED

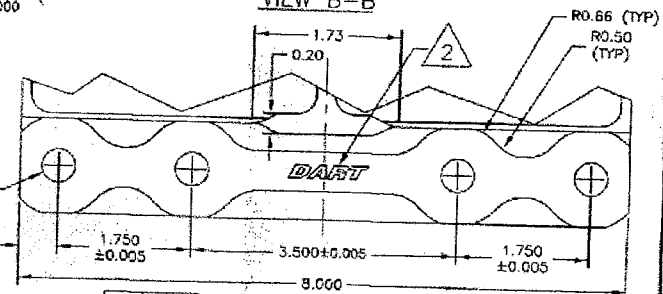
05.12.06

NOTES

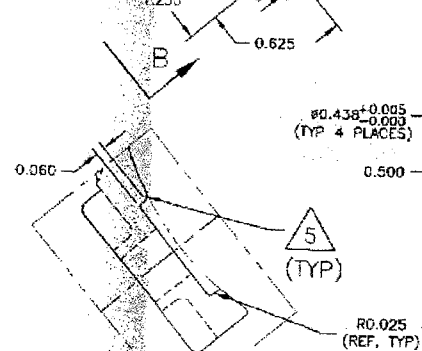
MATERIAL: 7075-T7351 (QQ-A-250/12)
(REF DART SPEC. D6102-001)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125
- 3 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 4 CHAMFER 0.063" x 45° ALL AROUND
- 5 CHAMFER 0.033" x 45° (SEE DETAIL C)

VIEW B-B

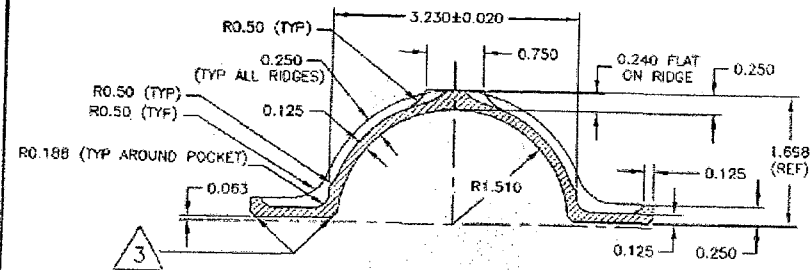


DETAIL C



DETAIL C
SCALE 4:3

SECTION A-A



E	05.07.13	ADD CHAMFER ON RIDGE NOTE 5
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCRP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE

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DESIGN	DS	DRAWN BY	PH	DART AEROSPACE LTD. HUNTSLEY, OXFORD, OX40D
CHECKED	#	APPROVED	#	DRAWING NO. D2573
DATE	05.07.13	TITLE	OUTER AFT SADDLE	REV. E SHEET 1 OF 1 SCALE 2:3